

Date: Thursday, 9/20/2007 3:29:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	34751	Part Number	D2574
Estimate Number	10534	Drawing Number	D2574 REV E
P.O. Number	N/A	Project Number	N/A
This Issue	9/20/2007	Type	MACHINED PARTS
Prsht Rev.	NC	Drawing Revision	E
First Issue	N/A	Material	N/A
Previous Run	34370	Due Date	10/1/2007
Written By		Qty:	12 Um: Each
Checked & Approved By			
Comment	Est Rev. 4 As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



Seq.#:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
		<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)            7075-T7351 8.25X5.0X2.5            Make from D6101-005 billet for D2574            Ensure that grain is along 5.00" length            Batch No: <u>B31388</u></p> <p style="text-align: right;"><i>JL 07/10/02</i> 12</p>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		<p>Comment: HAAS CNC VERTICAL MACHINING #1            Program Batch No: <u>34751</u> Double check by: <u>BC</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets            2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets            3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets            4-Deburr and remove all machining marks            5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><i>JL/BC 07.10.101 (12)</i></p>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		<p>Comment: CONVENTIONAL MILLING MACHINE            Machine keyway as per dwg D2573 &amp; D2574</p> <p style="text-align: right;"><i>J.L/BC 07.10.101 (12)</i></p>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><i>J.L/BC 07.10.101 (12)</i></p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D Date: 07/16/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:29:14 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34751

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

9/2 07/10/15

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/10/15

7.0 POWDER COATING POWDER COATING



M105088

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

el

09-10-16

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



G 09/10/16 (12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

G 09/10/16 (12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07/10/17

(12)

Job Completion



1 07/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

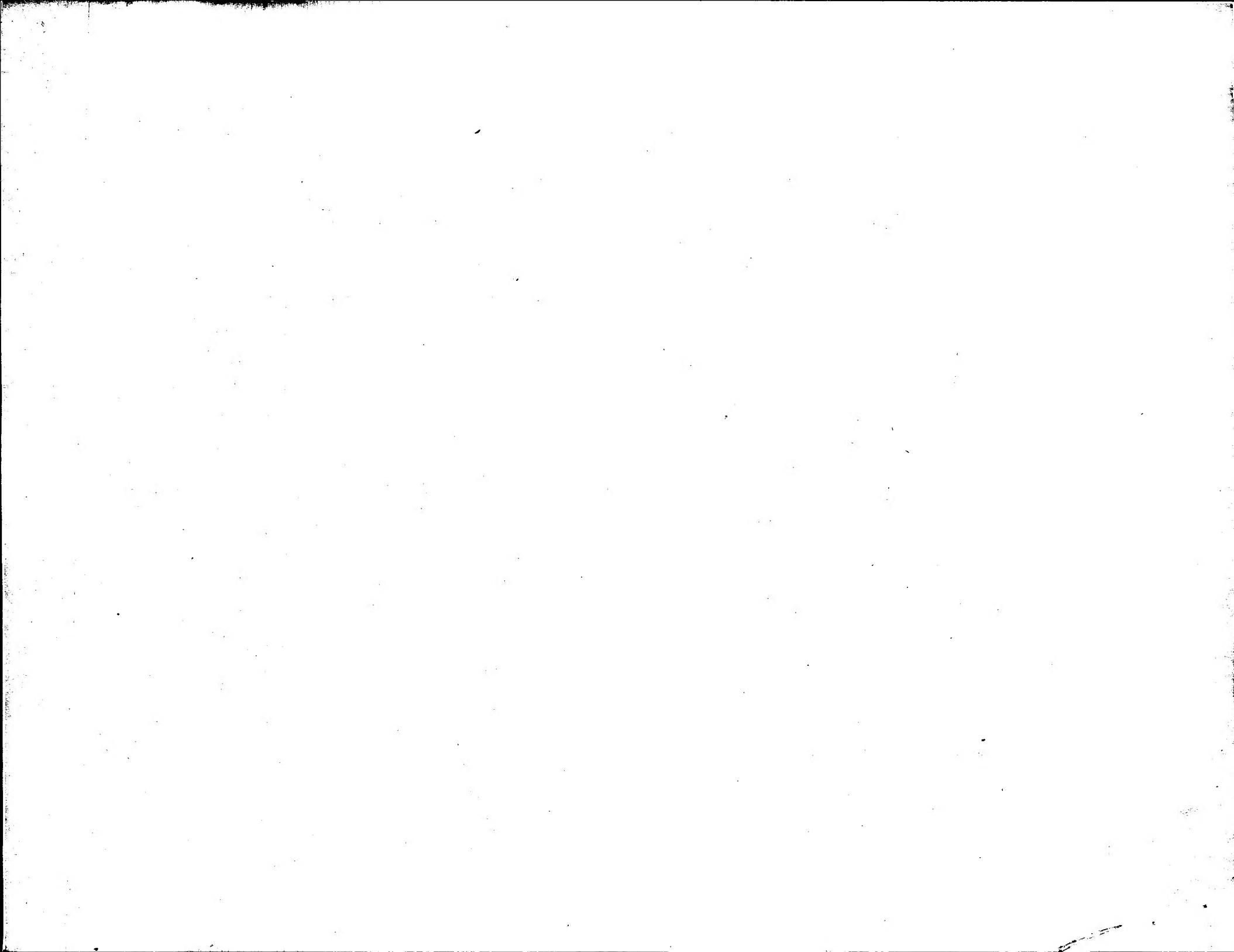
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.506	3.500	3.498	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	8.007	8.007		
F	0.490	0.510		0.501	.503	.502	.500		
G	0.257	0.262	-DT8683-	0.259	0.258	0.258	.254		
H	0.375	0.380	DI8684	0.377	0.377	0.376	.377		
I	0.490	0.510		0.502	0.501	0.502	.502		
J	1.174	1.184		1.179	1.179	1.178	1.181		
K	0.558	0.578		0.570	0.570	0.570	.570		
L	1.174	1.184		1.179	1.179	1.178	1.181		
M	1.365	1.375		1.369	1.369	1.368	1.368		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.125		
P	0.115	0.135		0.124	0.124	0.124	.125		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.249	0.248	0.249	.250		
S	0.115	0.135		0.129	0.129	0.128	.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.237	.237		
W	0.115	0.135		0.129	.127	.127	.127		
X	0.307	0.312		0.311	.311	.311	.311		
Y	0.760	0.765		0.760	.760	.764	.764		
Z	0.352	0.372		0.366	.366	.370	.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.626	.624	.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.247	.247		
AE	1.500	1.520		1.509	1.510	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	.136		
AG	0.240	0.280		0.265	0.275	0.270	.270		
AH	0.240	0.260		0.249	0.247	0.248	.246		
AI	2.000	2.020		2.000	2.001	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JL / J.L.  
Date: 02.10.14

Audited by: Amj  
Date: 07.10.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JL</u> <u>JL</u>



DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

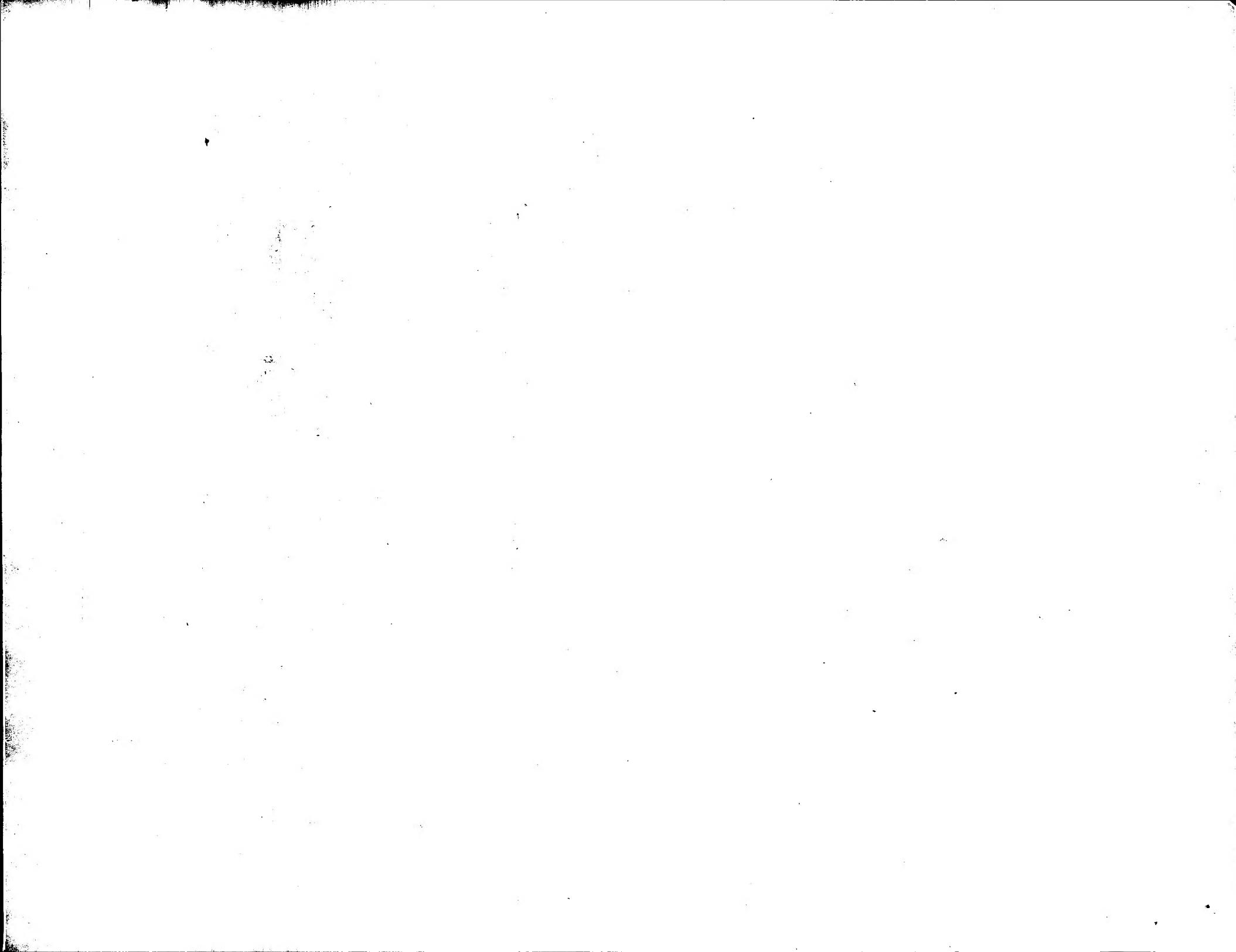
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5*	62	73	84	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.005		
F	0.490	0.510		.508	.508	.508	.508		
G	0.257	0.262	DT8683	.259	.259	.259	.259		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.506	.506	.505	.505		
J	1.174	1.184		1.183	1.183	1.183	1.181		
K	0.558	0.578		.576	.572	.572	.572		
L	1.174	1.184		1.182	1.183	1.183	1.181		
M	1.365	1.375		1.371	1.371	1.372	1.371		
N	2.495	2.505		2.500	2.501	2.500	2.499		
O	4.119	4.129		4.121	4.124	4.124	4.123		
P	0.115	0.135		.124	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.251	.251	.251		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.183	.188	.188	.188		
U	3.210	3.250		3.230	3.234	3.234	3.231		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.120	.122	.122	.122		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.369	.369	.369	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.510	1.511"		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		.040	.040	.040	.040		
Accept/Reject									

Measured by: S.F  
Date: 07/10/15

Audited by: G.M.  
Date: 07/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.438	0.443	DT8682	.4410	.4416	.4410	.4410		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		.505	.505	.505	.505		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.376	.376	.376		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.571	.571		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.125	.125	.125		
Q	0.115	0.135		.132	.132	.132	.132		
R	0.240	0.260		.251	.250	.250	.250		
S	0.115	0.135		.132	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.232	3.232	3.232		
V	0.230	0.250		.237	.237	.237	.237		
W	0.115	0.135		.130	.130	.130	.130		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.252	.252	.252		
AE	1.500	1.520		1.509	1.509	1.509	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.256	.270	.270	.270		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		.2010	.2010	.2010	.2010		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>John</i>	Audited by:	<i>John</i>
Date:	07/10/07	Date:	07/10/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>John JLM</i>	

